












Date: Wednesday, 5/31/2006 2:37:56 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: X-TUBE MATERIAL
Job Number	: 27318		
Estimate Number	: 12413		
P.O. Number	: <i>NIA</i>	Part Number	: D6015125
This Issue	: 5/31/2006 S.O. No. : <i>NIA</i>	Drawing Number	: D6015 PRELIMINARY
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>NIA</i> Type : PURCHASED PARTS	Drawing Revision	: PRE
Previous Run	: <i>NIA</i>	Material	: <i>NIA</i>
Written By	: <i>SEE COMMENT BELOW</i>	Due Date	: 6/15/2006 Qty: 8 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est Rev:A New Issue 06-05-13 JLM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	PG	PURCHASING	
			
Comment: PURCHASING Issue P/O: <i>1379</i> AISI 4130 (AMS 6371) Seamless steel tube 2.500 OD X 0.250" Wall Normalized & Annealed <i>46.06.01</i> Tolerances as per Dwg D6015 Mterial Certification is Required <i>C206106101 (8)</i>			
2.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached <i>AL 06/06/06 (8)</i>			
3.0	QC6	DIMENSIONAL CHECK	
			
Comment: DIMENSIONAL CHECK As Per Dwg D6015 <i>BC 06.07.11 8</i>			
4.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>CAC</i> <i>BC 06.07.11 8</i>			
5.0	DC	DOCUMENT CONTROL	
			
Comment: DOCUMENT CONTROL Inspection Level 21 <i>U 06.07.12 (8)</i>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *DX* Date: 06/07/12

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

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			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



MICHIGAN

seamless tube

9026

MICHIGAN SEAMLESS TUBE

TEST REPORT

SOUTH LYON, MICHIGAN 48178

SH

ORDER NUMBER	CUSTOMER ORDER NUMBER	DATE	OFC	COM	DIW	NET SLS	GR SLS	ACCOUNT NUMBER	US	1J
020463	092105MC	09/22/05	22	00	16	16	01	02598001FCO		

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FACTORY STEEL & METAL SUPPLY
14020 OAKLAND

DETROIT MI 48203

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FACTORY STEEL & METAL SUPPLY
14020 OAKLAND AVENUE
DETROIT MI 48203

ROUTING OPEN TOP/FULLY TARPED/FOB SOUTH LYON MI PPD TRUCK

OPEN 10/14/05						REQUIS
4130	ANALYSIS	SHAPE	PRODUCT	FC	PER SPEC	10/14/05
		ROUND	COLD DRAWN			
		SPECIFICATION	QNTY	DESCRIPTION		10/14/05
		AMS6371/AS19		CR ALLOY AIRCRAFT		
SEAMLESS						

SEAMLESS TUBE YLD, AIM 90 PSI, CERT TO AS19-96, MILT-6736BN NOTE-2
AMS-6360K W/DECARB LEVELS TO AMS-6371J, AMS-T-6736AN, 4130H &
AMS-2301J. T/R W/SHPT INCL CHEM, PHYS, DECARB, JOM, GRN SIZE & BRIN.
PRODUCE FROM 1-HEAT. MARK TO INCL GRADE, AS19-96, MILT-6736DN
NOTE-2, AMS-T6736AN, AMS-6371J, AMS6360K & 4130H. PAINT ENDS RED.

ITEM	QUANTITY	O.D.	I.D.	WALL	LENGTH	WT/FT	WEIGHT
		2.500		.250 AVG		6.008	15: 10/

ITM	BALE	--BALE--	PCS	PTG	HEAT NO.	LENGTH	ITM	PART
NUM	NUM						STATUS	NUMBER
1	1 2	20	494	000017514	RAND	19'-26'	COM	
1	2 2	16	399	000017514	RAND	19'-26'	COM	
1	3 2	4	100	000017514	RAND	19'-26'	COM	

HEAT NO.	C	Mn	P	S	Si	Ni	Cr	Mo	Cu	Al	RE
000017514	.300	.500	.007	.005	.350	.050	.990	.209	.070	.032	EF OEI

MECHANICAL PROP.	HEAT NO.	ULT. STR. PSI	YIELD, PSI	% ELONG "	HARDNESS	HYDRO TEST PSI		ULTRA SONIC %	EDDY CURRENT
	000017514	117,283	109,053	21.8	BHN 241-255				OK
						BEND	FLATTEN	FLARE	REV. FLATTEN

DECARB OR GRAIN SIZE ?

FREQ 0.000 SEV 0.000

MACROS S1, R1, C1

J1 J2 J3 J4 J5 J6 J7 J8 J9 J10

51 49 48 44 42 37 35 33 32 31

#31-5381097

Guo Linster

We hereby certify that the reported data a
according to Michigan Seamless Tube
those of its suppliers.